

Work Order ID 100289-1 *SPLIT*

\*100289\*

Page 1

April-22-13 12:52:50 PM

Item ID: D2571

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Saddle, Fwd Out 205

Start Date: 4/25/13 Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 5/03/13 Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Approvals: Process Plan: *ML5*

Date: *1304-24*

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D2571

F

100

0.00

\*100\*

HAAS CNC VERTICAL MACHINING #1

HAAS I

0.00

HAAS CNC vertical machine #1

Memo

Program Batch No. *100289*

Double check by: *[Signature]*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect

110

0.00

\*110\*

CONVENTIONAL MILLING MACHINE

Mill Conv

0.00

Conventional Milling Machine

Memo

Machine keyway as per dwg D2571 & D2572

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|  |      |      |     |   |                   |   |             |              |              |  |  |
|--|------|------|-----|---|-------------------|---|-------------|--------------|--------------|--|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ |      |      |     | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> |                   | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |             |              |              |  |  |
| Root Cause   | Date | Step | Qty | Description of work order update or Non-conformance   | Initial Chief Eng | Action Description  | Sign & Date | Verification | QC Inspector |  |  |
| Doc/Data   |      |      |     |   |                   |   |             |              |              |  |  |
| Equip/Tooling  |      |      |     |   |                   |   |             |              |              |  |  |
| Operator   |      |      |     |   |                   |   |             |              |              |  |  |
| Material   |      |      |     |   |                   |   |             |              |              |  |  |
| Setup  |      |      |     |   |                   |   |             |              |              |  |  |
| Other  |      |      |     |   |                   |   |             |              |              |  |  |
| Process  |      |      |     |   |                   |   |             |              |              |  |  |
| Supplier   |      |      |     |   |                   |   |             |              |              |  |  |
| Training   |      |      |     |   |                   |   |             |              |              |  |  |
| Unapproved   |      |      |     |   |                   |   |             |              |              |  |  |

  

| FAULT CATEGORY  |   |   |   |
|---|---|---|---|
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric to O/S<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crushed/Crimped<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Ripples in Bend<br><input type="checkbox"/> Torque Waves in Extrusion<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damaged<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Folio | <input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Maintenance<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Offset<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence<br><input type="checkbox"/> Outside Dimensions | <input type="checkbox"/> Ovalized<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge<br><br><input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><br><input type="checkbox"/> Other |

# Work Order ID 100289

April-22-13 12:52:50 PM

\*100289\*

Page 2

Item ID: D2571 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Saddle, Fwd Out 205  
 Start Date: 4/25/13 Start Qty: 12.00 \*12\* Cust Item ID:  
 Required Date: 5/03/13 Req'd Qty: 12.00 \*12\* Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

| Sequence ID/<br>Work Center ID               | Operation<br>Description                            | Set Up/<br>Run Hours | Tool ID | Tool #    | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp    |
|--|---|----------------------|---------|-----------|--------------|---------------|---------------|------------------|-------------------|
| 120<br>*120*<br>QC<br>Quality Control        | QC2- Inspect parts off machine FAI/FAIB<br><br>Memo | 0.00<br><br>0.00     |         | A13-05-20 |              | 6             | 0             |                  |                   |
| 130<br>*130*<br>QC<br>Quality Control        | QC8- Inspect parts - second check<br><br>Memo       | 0.00<br><br>0.00     |         | B-5-27    |              | 6             | 0             |                  | DAS<br>04<br>2-83 |
| 140<br>*140*<br>HandFinish<br>Hand Finishing | Chemical Conversion Coat per QSI005 4.1<br><br>Memo | 0.00<br><br>0.00     |         |           |              | 6             | 26            | 13523            |                   |



NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|                   |   |  |                                    |  |                                      |
|-------------------|---|--|------------------------------------|--|--------------------------------------|
| Work Order: _____ | <b>DISPOSITION</b><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b>      |                                    |  |                                      |
| Part No. _____    |   | Skid-tube <input type="checkbox"/>     | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/>           | Engineering <input type="checkbox"/> |
| NCR No. _____     |   | Machining <input type="checkbox"/>     | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/>   | Quality <input type="checkbox"/>     |
|                   |   | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/>       |
|                   |   | Large Fab <input type="checkbox"/>     | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/>            |                                      |

| Root Cause    | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data      |      |      |     |   |                   |                    |             |              |              |
| Equip/Tooling |      |      |     |   |                   |                    |             |              |              |
| Operator      |      |      |     |   |                   |                    |             |              |              |
| Material      |      |      |     |   |                   |                    |             |              |              |
| Setup         |      |      |     |   |                   |                    |             |              |              |
| Other         |      |      |     |   |                   |                    |             |              |              |
| Process       |      |      |     |   |                   |                    |             |              |              |
| Supplier      |      |      |     |   |                   |                    |             |              |              |
| Training      |      |      |     |   |                   |                    |             |              |              |
| Unapproved    |      |      |     |   |                   |                    |             |              |              |

## FAULT CATEGORY

| Landing Gear  | General  |
|---|--|
| <input type="checkbox"/> Bending                      | <input type="checkbox"/> Bend                            |
| <input type="checkbox"/> Centre Not Concentric to O/S | <input type="checkbox"/> BOM/Route                       |
| <input type="checkbox"/> Cracks                       | <input type="checkbox"/> Broken/Damaged                  |
| <input type="checkbox"/> Crushed/Crimped              | <input type="checkbox"/> Burrs                           |
| <input type="checkbox"/> Cuffs                        | <input type="checkbox"/> Contamination                   |
| <input type="checkbox"/> Heat Treat                   | <input type="checkbox"/> Countersink                     |
| <input type="checkbox"/> Inspection Strip in Tube     | <input type="checkbox"/> Cut Too Short                   |
| <input type="checkbox"/> Ripples in Bend              | <input type="checkbox"/> Drill Holes                     |
| <input type="checkbox"/> Torque Waves in Extrusion    | <input type="checkbox"/> Drawing                         |
| <input type="checkbox"/> Turning Sequence             | <input type="checkbox"/> Finish                          |
| <input type="checkbox"/> Wave/Twist in Tube           | <input type="checkbox"/> Folio                           |
|   | <input type="checkbox"/> Grain                           |
|   | <input type="checkbox"/> Hardware                        |
|   | <input type="checkbox"/> Inspection Incomplete           |
|   | <input type="checkbox"/> Instructions Incomplete/Unclear |
|   | <input type="checkbox"/> Maintenance                     |
|   | <input type="checkbox"/> Mislabeled                      |
|   | <input type="checkbox"/> Misread                         |
|   | <input type="checkbox"/> Offset                          |
|   | <input type="checkbox"/> Out of Calibration              |
|   | <input type="checkbox"/> Out of Sequence                 |
|   | <input type="checkbox"/> Outside Dimensions              |
|   | <input type="checkbox"/> Ovalized                        |
|   | <input type="checkbox"/> Over/Under tolerance            |
|   | <input type="checkbox"/> Part Incorrect                  |
|   | <input type="checkbox"/> Part Lost/Missing               |
|   | <input type="checkbox"/> Part Moved                      |
|   | <input type="checkbox"/> Positioned Wrong                |
|   | <input type="checkbox"/> Power Loss/Surge                |
|   | <input type="checkbox"/> Pressure/Forced                 |
|   | <input type="checkbox"/> Temperature/Cure                |
|   | <input type="checkbox"/> Weld                            |
|   | <input type="checkbox"/> Wrong Stock Pulled              |
|   | <input type="checkbox"/> Other                           |

## Work Order ID 100289

April-22-13 12:52:50 PM

\*100289\*

Page 3

Item ID: D2571

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Saddle, Fwd Out 205

Start Date: 4/25/13 Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 5/03/13 Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N): Date:

Stop \*NR2\*

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

\*150\*

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:00  
3200F  
12:30

6xØm-f13/05/23

160

QC3- Inspect Part Finish

0.00

\*160\*

QC

Quality Control

Memo

0.00

6 φ 13 5-23

170

Identify as per dwg &amp; Stock Location:

0.00

\*170\*

Packaging

Packaging

Memo

0.00

13/05/23 (6)

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|  |   |  |
|--|---|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ | <b>DISPOSITION</b><br><br><div style="display: flex; justify-content: space-around;"> <div>Rework <input type="checkbox"/></div> <div>Skid-tube <input type="checkbox"/></div> <div>Crosstube <input type="checkbox"/></div> <div>Water Jet <input type="checkbox"/></div> <div>Engineering <input type="checkbox"/></div> </div> <div style="display: flex; justify-content: space-around;"> <div>Scrap <input type="checkbox"/></div> <div>Machining <input type="checkbox"/></div> <div>Small Fab <input type="checkbox"/></div> <div>Prod. Eng. Coord. <input type="checkbox"/></div> <div>Quality <input type="checkbox"/></div> </div> <div style="display: flex; justify-content: space-around;"> <div>Use-as-is <input type="checkbox"/></div> <div>Thermoforming <input type="checkbox"/></div> <div>Finishing <input type="checkbox"/></div> <div>Rec/Store/Packaging <input type="checkbox"/></div> <div>Other <input type="checkbox"/></div> </div> <div style="display: flex; justify-content: space-around;"> <div>Work Order Update <input type="checkbox"/></div> <div>Large Fab <input type="checkbox"/></div> <div>Composite <input type="checkbox"/></div> <div>Supplier <input type="checkbox"/></div> </div> |  |
|--|---|--|

| Root Cause    | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data      |      |      |     |   |                   |                    |             |              |              |
| Equip/Tooling |      |      |     |   |                   |                    |             |              |              |
| Operator      |      |      |     |   |                   |                    |             |              |              |
| Material      |      |      |     |   |                   |                    |             |              |              |
| Setup         |      |      |     |   |                   |                    |             |              |              |
| Other         |      |      |     |   |                   |                    |             |              |              |
| Process       |      |      |     |   |                   |                    |             |              |              |
| Supplier      |      |      |     |   |                   |                    |             |              |              |
| Training      |      |      |     |   |                   |                    |             |              |              |
| Unapproved    |      |      |     |   |                   |                    |             |              |              |

**FAULT CATEGORY**

|   |   |   |
|---|---|---|
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric to O/S<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crushed/Crimped<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Ripples in Bend<br><input type="checkbox"/> Torque Waves in Extrusion<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damaged<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Folio | <input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Maintenance<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Offset<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence<br><input type="checkbox"/> Outside Dimensions |
| <input type="checkbox"/> Ovalized<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge  |   |   |
| <input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><input type="checkbox"/> Other   |   |   |



Work Order ID 100289

April-22-13 12:52:50 PM

\*100289\*

Page 4

Item ID: D2571 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Saddle, Fwd Out 205  
Start Date: 4/25/13 Start Qty: 12.00 \*12\* Cust Item ID:  
Required Date: 5/03/13 Req'd Qty: 12.00 \*12\* Customer:  
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
QC: Date: SPC (Y/N): Date: Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description                    | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 180                            | QC21- Final Inspection - Work Order Release | 0.00                 |         |        |              |               |               |                  |                |
| *180*                          |   |                      |         |        |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |

13/5/27 [Signature]  
P 1305-24

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|                   |   |  |                                    |  |                                      |
|-------------------|---|--|------------------------------------|--|--------------------------------------|
| Work Order: _____ | <b>DISPOSITION</b><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b>      |                                    |  |                                      |
| Part No. _____    |   | Skid-tube <input type="checkbox"/>     | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/>           | Engineering <input type="checkbox"/> |
| NCR No. _____     |   | Machining <input type="checkbox"/>     | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/>   | Quality <input type="checkbox"/>     |
|                   |   | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/>       |
|                   |   | Large Fab <input type="checkbox"/>     | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/>            |                                      |

| Root Cause    | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data      |      |      |     |   |                   |                    |             |              |              |
| Equip/Tooling |      |      |     |   |                   |                    |             |              |              |
| Operator      |      |      |     |   |                   |                    |             |              |              |
| Material      |      |      |     |   |                   |                    |             |              |              |
| Setup         |      |      |     |   |                   |                    |             |              |              |
| Other         |      |      |     |   |                   |                    |             |              |              |
| Process       |      |      |     |   |                   |                    |             |              |              |
| Supplier      |      |      |     |   |                   |                    |             |              |              |
| Training      |      |      |     |   |                   |                    |             |              |              |
| Unapproved    |      |      |     |   |                   |                    |             |              |              |

## FAULT CATEGORY

| Landing Gear  | General  |
|---|--|
| <input type="checkbox"/> Bending                      | <input type="checkbox"/> Bend                            |
| <input type="checkbox"/> Centre Not Concentric to O/S | <input type="checkbox"/> BOM/Route                       |
| <input type="checkbox"/> Cracks                       | <input type="checkbox"/> Broken/Damaged                  |
| <input type="checkbox"/> Crushed/Crimped              | <input type="checkbox"/> Burrs                           |
| <input type="checkbox"/> Cuffs                        | <input type="checkbox"/> Contamination                   |
| <input type="checkbox"/> Heat Treat                   | <input type="checkbox"/> Countersink                     |
| <input type="checkbox"/> Inspection Strip in Tube     | <input type="checkbox"/> Cut Too Short                   |
| <input type="checkbox"/> Ripples in Bend              | <input type="checkbox"/> Drill Holes                     |
| <input type="checkbox"/> Torque Waves in Extrusion    | <input type="checkbox"/> Drawing                         |
| <input type="checkbox"/> Turning Sequence             | <input type="checkbox"/> Finish                          |
| <input type="checkbox"/> Wave/Twist in Tube           | <input type="checkbox"/> Folio                           |
|   | <input type="checkbox"/> Grain                           |
|   | <input type="checkbox"/> Hardware                        |
|   | <input type="checkbox"/> Inspection Incomplete           |
|   | <input type="checkbox"/> Instructions Incomplete/Unclear |
|   | <input type="checkbox"/> Maintenance                     |
|   | <input type="checkbox"/> Misabeled                       |
|   | <input type="checkbox"/> Misread                         |
|   | <input type="checkbox"/> Offset                          |
|   | <input type="checkbox"/> Out of Calibration              |
|   | <input type="checkbox"/> Out of Sequence                 |
|   | <input type="checkbox"/> Outside Dimensions              |
|   | <input type="checkbox"/> Ovalized                        |
|   | <input type="checkbox"/> Over/Under tolerance            |
|   | <input type="checkbox"/> Part Incorrect                  |
|   | <input type="checkbox"/> Part Lost/Missing               |
|   | <input type="checkbox"/> Part Moved                      |
|   | <input type="checkbox"/> Positioned Wrong                |
|   | <input type="checkbox"/> Power Loss/Surge                |
|   | <input type="checkbox"/> Pressure/Forced                 |
|   | <input type="checkbox"/> Temperature/Cure                |
|   | <input type="checkbox"/> Weld                            |
|   | <input type="checkbox"/> Wrong Stock Pulled              |
|   | <input type="checkbox"/> Other                           |



# Picklist Print

April-22-13 12:52:49 PM

Page 1

Work Order ID: 100289

Parent Item: D2571

Parent Item Name: Saddle, Fwd Out 205

Start Date: 4/25/13

Required Date: 5/03/13

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: 102.10.02Re-format; Change to Dwg Rev. D & incorporated D2572KJ

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D6101-007<br>Saddle Billet      |                        | Manufactured  | No          |                     |                  | 100             | Each               | 37.0000        | 1           | 12           | 12            | 13-05-19       |        |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT041   | 36      |          |
| 85432    | 1       |          |
| 88516    | 4       |          |
| 89349    | 3       |          |
| 92730    | 20      |          |
| 98465    | 8       |          |
| MAT042   | 1       |          |
| 85432    | 1       |          |

99174

12

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|  |   |   |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
|--|---|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/>   | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> |  |
| Skid-tube <input type="checkbox"/>                           | Crosstube <input type="checkbox"/>  | Water Jet <input type="checkbox"/>  | Engineering <input type="checkbox"/> |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Machining <input type="checkbox"/>                           | Small Fab <input type="checkbox"/>  | Prod. Eng. Coord. <input type="checkbox"/>  | Quality <input type="checkbox"/>     |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Thermoforming <input type="checkbox"/>                       | Finishing <input type="checkbox"/>  | Rec/Store/Packaging <input type="checkbox"/>  | Other <input type="checkbox"/>       |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Large Fab <input type="checkbox"/>                           | Composite <input type="checkbox"/>  | Supplier <input type="checkbox"/>   |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |

| Root Cause    | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data      |      |      |     |   |                   |                    |             |              |              |
| Equip/Tooling |      |      |     |   |                   |                    |             |              |              |
| Operator      |      |      |     |   |                   |                    |             |              |              |
| Material      |      |      |     |   |                   |                    |             |              |              |
| Setup         |      |      |     |   |                   |                    |             |              |              |
| Other         |      |      |     |   |                   |                    |             |              |              |
| Process       |      |      |     |   |                   |                    |             |              |              |
| Supplier      |      |      |     |   |                   |                    |             |              |              |
| Training      |      |      |     |   |                   |                    |             |              |              |
| Unapproved    |      |      |     |   |                   |                    |             |              |              |

## FAULT CATEGORY

| Landing Gear  | General                                 | Other  |
|---|---|--|
| <input type="checkbox"/> Bending                      | <input type="checkbox"/> Bend           | <input type="checkbox"/> Grain                           |
| <input type="checkbox"/> Centre Not Concentric to O/S | <input type="checkbox"/> BOM/Route      | <input type="checkbox"/> Hardware                        |
| <input type="checkbox"/> Cracks                       | <input type="checkbox"/> Broken/Damaged | <input type="checkbox"/> Inspection Incomplete           |
| <input type="checkbox"/> Crushed/Crimped              | <input type="checkbox"/> Burrs          | <input type="checkbox"/> Instructions Incomplete/Unclear |
| <input type="checkbox"/> Cuffs                        | <input type="checkbox"/> Contamination  | <input type="checkbox"/> Maintenance                     |
| <input type="checkbox"/> Heat Treat                   | <input type="checkbox"/> Countersink    | <input type="checkbox"/> Mislabeled                      |
| <input type="checkbox"/> Inspection Strip in Tube     | <input type="checkbox"/> Cut Too Short  | <input type="checkbox"/> Misread                         |
| <input type="checkbox"/> Ripples in Bend              | <input type="checkbox"/> Drill Holes    | <input type="checkbox"/> Offset                          |
| <input type="checkbox"/> Torque Waves in Extrusion    | <input type="checkbox"/> Drawing        | <input type="checkbox"/> Out of Calibration              |
| <input type="checkbox"/> Turning Sequence             | <input type="checkbox"/> Finish         | <input type="checkbox"/> Out of Sequence                 |
| <input type="checkbox"/> Wave/Twist in Tube           | <input type="checkbox"/> Folio          | <input type="checkbox"/> Outside Dimensions              |
|   |   | <input type="checkbox"/> Ovalized                        |
|   |   | <input type="checkbox"/> Over/Under tolerance            |
|   |   | <input type="checkbox"/> Part Incorrect                  |
|   |   | <input type="checkbox"/> Part Lost/Missing               |
|   |   | <input type="checkbox"/> Part Moved                      |
|   |   | <input type="checkbox"/> Positioned Wrong                |
|   |   | <input type="checkbox"/> Power Loss/Surge                |
|   |   | <input type="checkbox"/> Pressure/Forced                 |
|   |   | <input type="checkbox"/> Temperature/Cure                |
|   |   | <input type="checkbox"/> Weld                            |
|   |   | <input type="checkbox"/> Wrong Stock Pulled              |
|   |   | <input type="checkbox"/> Other                           |



|  |                     |             |
|--|---------------------|-------------|
| <b>DART AEROSPACE LTD</b>                | <b>Work Order:</b>  | 100289      |
| <b>Description:</b> Saddle, Fwd Outboard | <b>Part Number:</b> | D2571       |
| <b>Inspection Dwg:</b> D2571 Rev. F      |                     | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

| Dim | Min   | Max   | Go/No Go Gauge | Recorded Actual Dimensions |       |       |       | By | Date |
|-----|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
|     |       |       |                | 1                          | 2     | 3     | 4     |    |      |
| A   | 0.438 | 0.443 |                | .439                       | .438  | .438  | .438  |    |      |
| B   | 1.745 | 1.755 |                | 1.749                      | 1.750 | 1.750 | 1.750 |    |      |
| C   | 3.495 | 3.505 |                | 3.500                      | 3.500 | 3.500 | 3.500 |    |      |
| D   | 1.745 | 1.755 |                | 1.749                      | 1.750 | 1.750 | 1.750 |    |      |
| E   | 7.990 | 8.010 |                | 8.000                      | 7.999 | 8.000 | 8.000 |    |      |
| F   | 0.490 | 0.510 |                | .499                       | .501  | .502  | .502  |    |      |
| G   | 0.257 | 0.262 |                | .258                       | .258  | .258  | .258  |    |      |
| H   | 0.375 | 0.380 |                | .376                       | .376  | .376  | .376  |    |      |
| I   | 0.490 | 0.510 |                | .500                       | .501  | .500  | .501  |    |      |
| J   | 1.174 | 1.184 |                | 1.179                      | 1.179 | 1.179 | 1.179 |    |      |
| K   | 0.558 | 0.578 |                | .567                       | .567  | .568  | .568  |    |      |
| L   | 1.174 | 1.184 |                | 1.179                      | 1.179 | 1.179 | 1.179 |    |      |
| M   | 1.490 | 1.500 |                | 1.494                      | 1.495 | 1.495 | 1.495 |    |      |
| N   | 2.495 | 2.505 |                | 2.498                      | 2.500 | 2.500 | 2.500 |    |      |
| O   | 3.869 | 3.879 |                | 3.871                      | 3.874 | 3.874 | 3.874 |    |      |
| P   | 0.115 | 0.135 |                | .125                       | .125  | .125  | .124  |    |      |
| Q   | 0.115 | 0.135 |                | .130                       | .130  | .130  | .130  |    |      |
| R   | 0.240 | 0.260 |                | .250                       | .251  | .250  | .248  |    |      |
| S   | 0.115 | 0.135 |                | .120                       | .125  | .125  | .127  |    |      |
| T   | 0.178 | 0.198 |                | .188                       | .188  | .188  | .188  |    |      |
| U   | 2.940 | 2.980 |                | 2.960                      | 2.960 | 2.960 | 2.960 |    |      |
| V   | 0.230 | 0.250 |                | .237                       | .240  | .238  | .242  |    |      |
| W   | 0.115 | 0.135 |                | .110                       | .121  | .121  | .121  |    |      |
| X   | 0.308 | 0.313 |                | .309                       | .310  | .310  | .310  |    |      |
| Y   | 0.760 | 0.765 |                | .760                       | .760  | .760  | .760  |    |      |
| Z   | 0.352 | 0.372 |                | .363                       | .361  | .364  | .364  |    |      |
| AA  | 0.470 | 0.530 |                | .500                       | .500  | .500  | .500  |    |      |
| AB  | 0.615 | 0.635 |                | .626                       | .628  | .627  | .626  |    |      |
| AC  | 0.053 | 0.073 |                | .063                       | .063  | .063  | .063  |    |      |
| AD  | 0.240 | 0.260 |                | .247                       | .251  | .249  | .251  |    |      |
| AE  | 1.375 | 1.395 |                | 1.391                      | 1.387 | 1.389 | 1.385 |    |      |
| AF  | 0.115 | 0.135 |                | .126                       | .130  | .130  | .130  |    |      |
| AG  | 0.240 | 0.280 |                | .255                       | .260  | .260  | .260  |    |      |
| AH  | 0.240 | 0.260 |                | .246                       | .249  | .248  | .251  |    |      |
| AI  | 2.000 | 2.020 |                | 2.006                      | 2.003 | 2.006 | 2.001 |    |      |
| AJ  | 0.023 | 0.043 |                | .033                       | .033  | .033  | .033  |    |      |

Accept/Reject

|              |          |
|--------------|----------|
| Measured by: | AS       |
| Date:        | 13-05-20 |

|             |          |
|-------------|----------|
| Audited by: | DAS      |
| Date:       | 13-05-23 |

| Rev | Date     | Change                                  | Revised by | Approved |
|-----|----------|---|------------|----------|
| B   | 02.09.24 | Re-format; Added Rev. D                 | KJ         |          |
| C   | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ         |          |
| D   | 05.05.05 | Added dimension AI                      | KJ/RF      |          |
| E   | 05.12.05 | Added dimension AJ                      | KJ/JLM     |          |
| F   | 13.03.07 | Dwg Rev updated                         | KJ         |          |



|  |                     |                    |
|--|---------------------|--------------------|
| <b>DART AEROSPACE LTD</b>                | <b>Work Order:</b>  | <b>100289</b>      |
| <b>Description:</b> Saddle, Fwd Outboard | <b>Part Number:</b> | <b>D2571</b>       |
| <b>Inspection Dwg:</b> D2571 Rev. F      |                     | <b>Page 1 of 1</b> |

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

| Dim           | Min   | Max   | Go/No Go Gauge | Recorded Actual Dimensions |       |        |        | By  | Date |
|---------------|-------|-------|----------------|----------------------------|-------|--------|--------|-----|------|
|               |       |       |                | 15                         | 26    | 37     | 48     |     |      |
| A             | 0.438 | 0.443 |                | .438                       | .438  | .438   | .438   |     |      |
| B             | 1.745 | 1.755 |                | 1.750                      | 1.750 | 1.748  | 1.748  |     |      |
| C             | 3.495 | 3.505 |                | 3.500                      | 3.500 | 3.498  | 3.498  |     |      |
| D             | 1.745 | 1.755 |                | 1.750                      | 1.750 | 1.748  | 1.748  |     |      |
| E             | 7.990 | 8.010 |                | 7.997                      | 8.009 |        |        |     |      |
| F             | 0.490 | 0.510 |                | .500                       | .509  |        |        |     |      |
| G             | 0.257 | 0.262 |                | .258                       | .258  | .258   | .258   |     |      |
| H             | 0.375 | 0.380 |                | .376                       | .376  | .376   | .376   |     |      |
| I             | 0.490 | 0.510 |                | .500                       | .498  | .500   |        |     |      |
| J             | 1.174 | 1.184 |                | 1.179                      | 1.179 | 1.176  |        |     |      |
| K             | 0.558 | 0.578 |                | .568                       | .566  | .566   |        |     |      |
| L             | 1.174 | 1.184 |                | 1.179                      | 1.179 | 1.176  |        |     |      |
| M             | 1.490 | 1.500 |                | 1.495                      | 1.495 | 1.493  |        |     |      |
| N             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.496  |        |     |      |
| O             | 3.869 | 3.879 |                | 3.874                      | 3.874 | 3.871  |        |     |      |
| P             | 0.115 | 0.135 |                | .125                       | .125  | .126   |        |     |      |
| Q             | 0.115 | 0.135 |                | .130                       | .130  | .130   |        |     |      |
| R             | 0.240 | 0.260 |                | .249                       | .250  | .250   |        |     |      |
| S             | 0.115 | 0.135 |                | .125                       | .127  | .122   |        |     |      |
| T             | 0.178 | 0.198 |                | .188                       | .188  | .188   | .188   |     |      |
| U             | 2.940 | 2.980 |                | 2.960                      | 2.960 | 2.960  |        |     |      |
| V             | 0.230 | 0.250 |                | .240                       | .241  | .239   |        |     |      |
| W             | 0.115 | 0.135 |                | .121                       | .122  | .121   |        |     |      |
| X             | 0.308 | 0.313 |                | .312                       | .311  |        |        |     |      |
| Y             | 0.760 | 0.765 |                | .760                       | .760  | .760   | .760   |     |      |
| Z             | 0.352 | 0.372 |                | .364                       | .364  |        |        |     |      |
| AA            | 0.470 | 0.530 |                | .500                       | .500  | .500   | .500   |     |      |
| AB            | 0.615 | 0.635 |                | .6275                      | .628  |        |        |     |      |
| AC            | 0.053 | 0.073 |                | .063                       | .063  | .063   | .063   |     |      |
| AD            | 0.240 | 0.260 |                | .252                       | .250  | .250   |        |     |      |
| AE            | 1.375 | 1.395 |                | 1.390                      | 1.388 | 1.3865 | 1.386  |     |      |
| AF            | 0.115 | 0.135 |                | .130                       | .130  | .130   | .130   |     |      |
| AG            | 0.240 | 0.280 |                | .260                       | .260  | .260   |        |     |      |
| AH            | 0.240 | 0.260 |                | .250                       | .251  | .250   |        |     |      |
| AI            | 2.000 | 2.020 |                | 2.009                      | 2.003 | 2.001  | 2.0007 |     |      |
| AJ            | 0.023 | 0.043 |                | .033                       | .033  | .033   | .033   |     |      |
| Accept/Reject |       |       |                |                            |       |        |        | DAS |      |

Measured by: *JK*  
Date: *13-5-22 / 13-05-23*

Audited by: *04*  
Date: *13-5-23*

| Rev | Date     | Change                                  | Revised by | Approved  |
|-----|----------|---|------------|-----------|
| B   | 02.09.24 | Re-format; Added Rev. D                 | KJ         |           |
| C   | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ         |           |
| D   | 05.05.05 | Added dimension AI                      | KJ/RF      |           |
| E   | 05.12.05 | Added dimension AJ                      | KJ/JLM     |           |
| F   | 13.03.07 | Dwg Rev updated                         | KJ         | <i>JK</i> |



|  |                     |             |
|--|---------------------|-------------|
| <b>DART AEROSPACE LTD</b>                | <b>Work Order:</b>  | 100289      |
| <b>Description:</b> Saddle, Fwd Outboard | <b>Part Number:</b> | D2571       |
| <b>Inspection Dwg:</b> D2571 Rev. F      |                     | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

| Dim           | Min   | Max   | Go/No Go Gauge | Recorded Actual Dimensions |       |       |       | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
|               |       |       |                | 9                          | 10    | 11    | 12    |    |      |
| A             | 0.438 | 0.443 |                | .438                       | .438  | .438  | .438  |    |      |
| B             | 1.745 | 1.755 |                | 1.750                      | 1.750 | 1.750 | 1.750 |    |      |
| C             | 3.495 | 3.505 |                | 3.500                      | 3.500 | 3.500 | 3.500 |    |      |
| D             | 1.745 | 1.755 |                | 1.750                      | 1.750 | 1.750 | 1.750 |    |      |
| E             | 7.990 | 8.010 |                |                            |       |       |       |    |      |
| F             | 0.490 | 0.510 |                |                            |       |       |       |    |      |
| G             | 0.257 | 0.262 |                | .258                       | .258  | .258  | .258  |    |      |
| H             | 0.375 | 0.380 |                | .376                       | .376  | .376  | .376  |    |      |
| I             | 0.490 | 0.510 |                |                            |       |       |       |    |      |
| J             | 1.174 | 1.184 |                |                            |       |       |       |    |      |
| K             | 0.558 | 0.578 |                |                            |       |       |       |    |      |
| L             | 1.174 | 1.184 |                |                            |       |       |       |    |      |
| M             | 1.490 | 1.500 |                |                            |       |       |       |    |      |
| N             | 2.495 | 2.505 |                |                            |       |       |       |    |      |
| O             | 3.869 | 3.879 |                |                            |       |       |       |    |      |
| P             | 0.115 | 0.135 |                |                            |       |       |       |    |      |
| Q             | 0.115 | 0.135 |                |                            |       |       |       |    |      |
| R             | 0.240 | 0.260 |                |                            |       |       |       |    |      |
| S             | 0.115 | 0.135 |                |                            |       |       |       |    |      |
| T             | 0.178 | 0.198 |                | .188                       | .188  | .188  | .188  |    |      |
| U             | 2.940 | 2.980 |                |                            |       |       |       |    |      |
| V             | 0.230 | 0.250 |                |                            |       |       |       |    |      |
| W             | 0.115 | 0.135 |                |                            |       |       |       |    |      |
| X             | 0.308 | 0.313 |                |                            |       |       |       |    |      |
| Y             | 0.760 | 0.765 |                | .760                       | .760  | .760  | .760  |    |      |
| Z             | 0.352 | 0.372 |                |                            |       |       |       |    |      |
| AA            | 0.470 | 0.530 |                | .500                       | .500  | .500  | .500  |    |      |
| AB            | 0.615 | 0.635 |                |                            |       |       |       |    |      |
| AC            | 0.053 | 0.073 |                | .063                       | .063  | .063  | .063  |    |      |
| AD            | 0.240 | 0.260 |                |                            |       |       |       |    |      |
| AE            | 1.375 | 1.395 |                |                            |       |       |       |    |      |
| AF            | 0.115 | 0.135 |                | .130                       | .130  | .130  | .130  |    |      |
| AG            | 0.240 | 0.280 |                |                            |       |       |       |    |      |
| AH            | 0.240 | 0.260 |                |                            |       |       |       |    |      |
| AI            | 2.000 | 2.020 |                |                            |       |       |       |    |      |
| AJ            | 0.023 | 0.043 |                | .033                       | .033  | .033  | .033  |    |      |
| Accept/Reject |       |       |                |                            |       |       |       |    |      |

|              |         |
|--------------|---------|
| Measured by: | JS      |
| Date:        | 13-5-23 |

|             |         |
|-------------|---------|
| Audited by: | RP      |
| Date:       | 13-5-23 |

| Rev | Date     | Change                                  | Revised by | Approved |
|-----|----------|---|------------|----------|
| B   | 02.09.24 | Re-format; Added Rev. D                 | KJ         |          |
| C   | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ         |          |
| D   | 05.05.05 | Added dimension AI                      | KJ/RF      |          |
| E   | 05.12.05 | Added dimension AJ                      | KJ/JLM     |          |
| F   | 13.03.07 | Dwg Rev updated                         | KJ         |          |



